



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200
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C3-4-2**Job Sheet 193377****Part No:** C3-4-2**Job Qty:** 20 pcs**Part Name:** Trunnion**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 4/12/19**Job Tracking No:****Due Date:** 4/15/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG C3-4-2 Rev 6 IPP Rev A 18.03.02 New issue DP Verify DD**Ship Via:**

ASAD

Bill of Materials**Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	SL-154 - 1	20 pcs	4/15/19	4/15/19	0.00	2.50	SL-154 - 1		<i>MD 19/04/15</i>
130	QC 2	20 pcs	4/15/19	4/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		<i>MD 19/04/15</i>
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

**Container No:** S172363**Part:** C3-4-2**Job No:** 193377**Serial No/Batch:** S172363**Revision:** 6**Inspector:****Exp Date:****Instructions:**

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Date: 04/15/19

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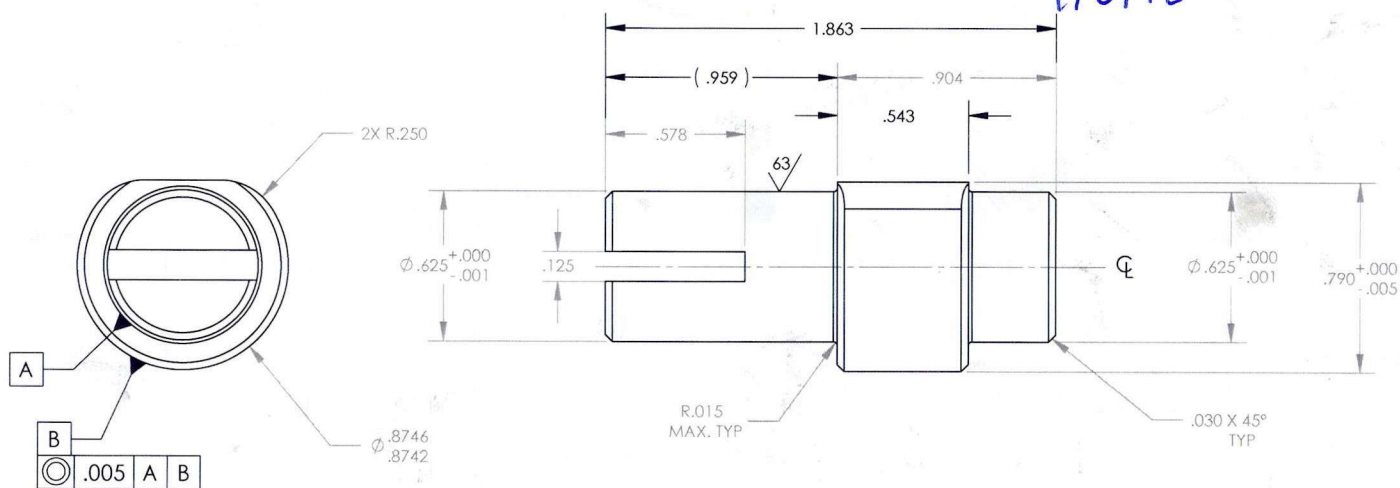
160 QC 8	20 pcs	4/15/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	B.p 19-04-16
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
200 Packaging 3-1 - Stock - B4B	20 pcs	4/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	

Das
28
9-89

				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210	QC 21 - SA	20 pcs	4/15/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 120 - MORI SL-154 LATHE - 1-Machine as per folio FB956 FOLIO REV: <u>AA</u> DWG REV: <u>6</u>					APR 17 2019 70
Descriptions: Deburr 130 - QC2- Inspect parts off machine FAI/FAIB 160 - QC8- Inspect parts - second check 200 - Identify as per dwg & Stock Location: _____ 210 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MT-4140QT-R1.000	AISI 4140 Quenched & Tempered Steel Round Bar 1.000" Dia.	3.8600 ft (.193 ea)	120-SL-154 - 1	5093068	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
120-SL-154 - 1	MT-4140QT-R1.000	4	25	0	
Part Specifications					
Specifications could not be found.					

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REVISION				
REV	DESCRIPTION	DATE	BY	APPROVE
1	CHD DEDUCTION FROM PAYS * 0.005 to 0.075 * 0.075; CHD DEDUCTION FROM PAYS * 0.005 to 0.075 * 0.075	5/8/2012	PJC	TE



 RED BARN MACHINE							
TITLE TRUNNION							
DWG NO. 	REV 6						
C3-4-2							
MAT'L 4140 Q&T UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES <table border="0" style="width: 100%;"> <tr> <td style="width: 50%;">.XXX ± .005</td> <td style="width: 50%;">FRACTIONS ± 1/32</td> </tr> <tr> <td>.XX ± .01</td> <td>ANGLES ± .1</td> </tr> <tr> <td>.X ± .1</td> <td></td> </tr> </table>	.XXX ± .005	FRACTIONS ± 1/32	.XX ± .01	ANGLES ± .1	.X ± .1		DRAWN BY: APICAL INDUSTRIES APPROVED: <i>P. Milled</i> REV TREAT FINISH SPEC NICKEL PLATE USED ON MODEL
.XXX ± .005	FRACTIONS ± 1/32						
.XX ± .01	ANGLES ± .1						
.X ± .1							
1. BREAK ALL SHARP EDGES .015 x .45" OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING							
SCALE 2:1	DATE 10/31/2001 SHEET 1 OF 1						

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			4-2	1	TRUNNION	4140 Q&T-	Ø7/8" X 2	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

